

Shp 25-26/05

Work Order ID 58962

May 20, 2010 11:53:04 AM



Page 1

Item ID: D3955-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover Plate

Start Date: 5/20/10 Start Qty: 3.00



Cust Item ID:

Required Date: 5/25/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3955 | A |

| | | |
|-----|----------|------|
| 100 | Waterjet | 0.00 |
|-----|----------|------|



FLOW CNC Waterjet

304.063

Memo

1-Cut as per Dwg D3955

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

HB10-5-25

③

| | | |
|-----|-----------------------------------------|------|
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 |
|-----|-----------------------------------------|------|



QC

Quality Control

Memo

HB10-5-25

0.0
0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 58962

May 20, 2010 11:53:04 AM



Page 2

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Revision ID:

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Item Name: Cover Plate

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Cust Item ID:

Required Date: 5/25/10 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

120 QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/12/25

3

130 Wing Walk as per dwg QSI005 4.4 Batch 114732

0.00



HandFinish

Memo

0.00

Hand Finishing

3 BL 10-5-25

140 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/05/25

3

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 58962

May 20, 2010 11:53:05 AM



Page 3

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---------------------------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 150 | Identify as per dwg & Stock Location: 102 | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

10-5-25 3x SP

10/05/26 JH
C21015/26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

May 20, 2010 11:53:03 AM

Page 1

Work Order ID: 58962



Parent Item: D3955-3



Parent Item Name: Cover Plate

Start Date: 5/20/10

Required Date: 5/25/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 3.00

Required Qty: 3.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| M304S16GA | | Purchased | No | | | 100 | sf | 64.8548 | 0.3553 | | | |



304/316 Sheet .063



1310-5-25

Location

Loc Qty

Loc Code

MAT

64.8548

111323

0

114467

64.8548

114467

3

| W/O: | | WORK ORDER CHANGES | | | | | |
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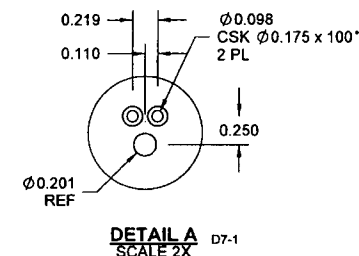
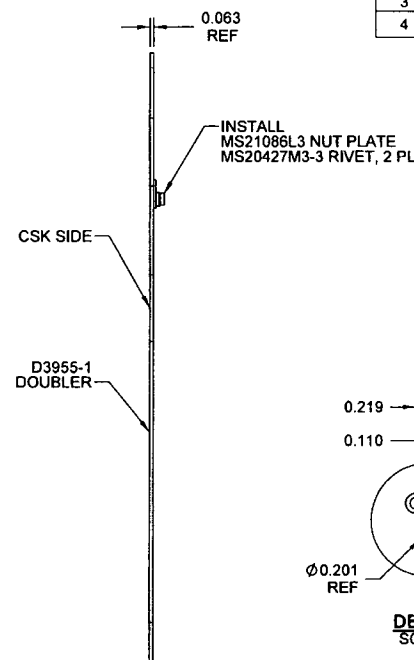
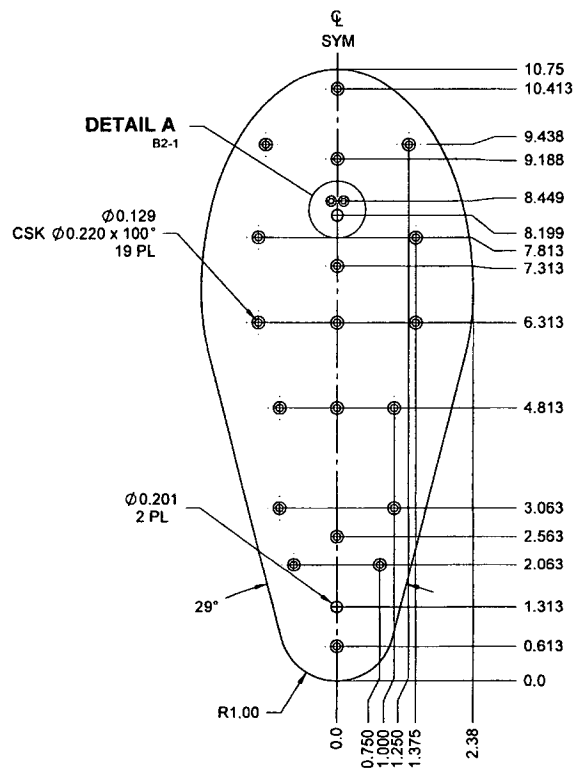
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-------------|--------------|
| 1 | X | D3955-041 | DOUBLER ASSY |
| 2 | 1 | D3955-1 | DOUBLER |
| 3 | 1 | MS21086L3 | NUT PLATE |
| 4 | 2 | MS20427M3-3 | RIVET |



D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASED
09/07/22

| | | | |
|-------------|-------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A NEW ISSUE | | RF | 09.07.21 |
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3955 | SHEET 1 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SKIDTUBE TUNING KIT | NTS |
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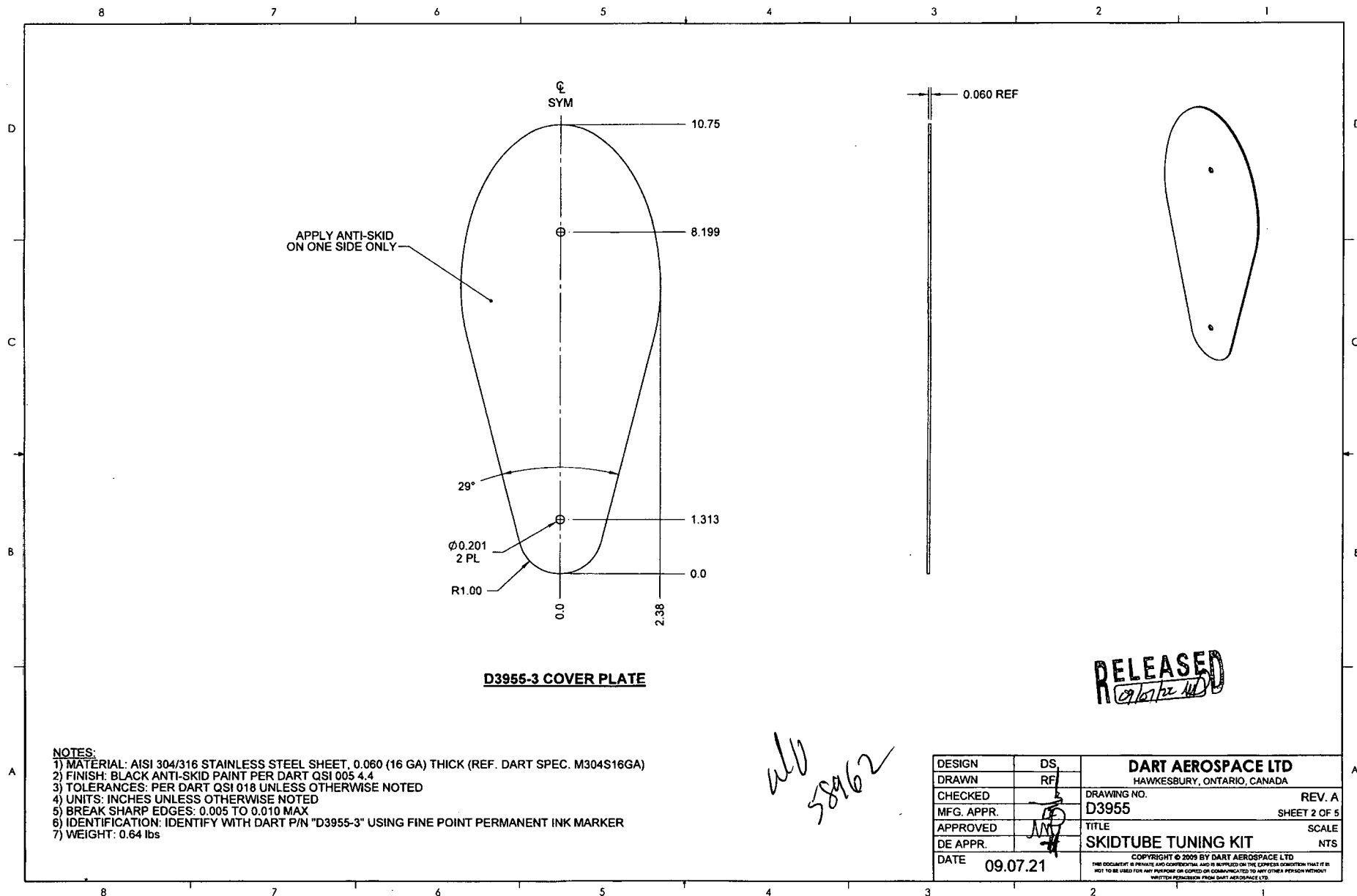
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



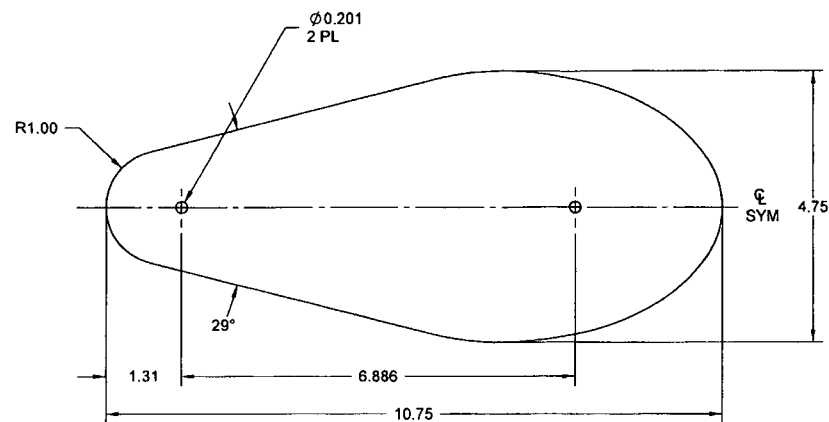
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NOTE: Date & initial all entries



D3955-X PLATE

| General Table | | | |
|---------------|--------|--------|--------------|
| P/N | T (in) | T (GA) | WEIGHT (lbs) |
| D3955-5 | 0.060 | 16 | 0.64 |
| D3955-7 | 0.120 | 11 | 1.28 |

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304STGA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

RELEASED
01/01/02 MDD

who 58962

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| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3955 | SHEET 3 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SKIDTUBE TUNING KIT | NTS |
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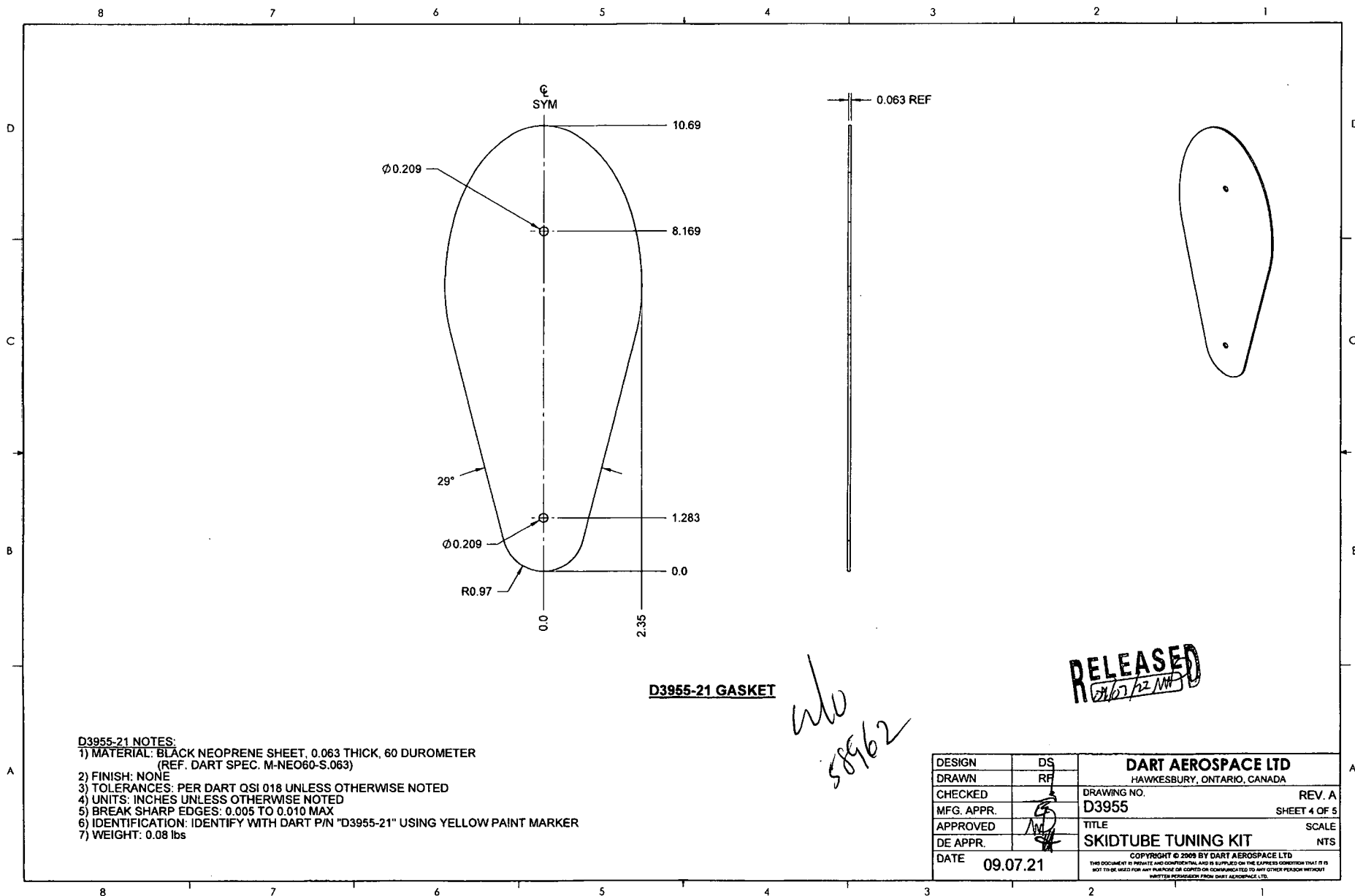
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NOTE: Date & initial all entries



D3955-21 GASKET

D3955-21 NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

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01/07/22 NW

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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
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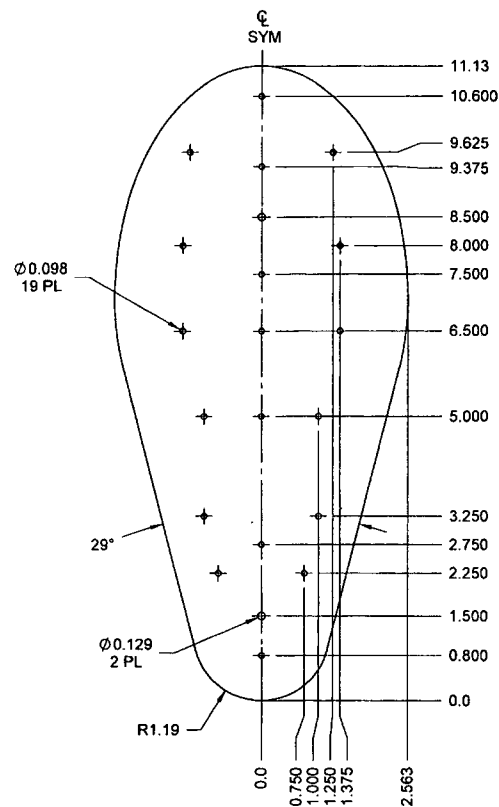
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NOTE: Date & initial all entries



D3955-23 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

WLB 88962

RELEASED
09/07/21

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| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
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